

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000383**Date Inspected:** 28-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA**CWI Name:** Michael Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Danny C. White (B89) is present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/Fluor (ABF) for the purpose of witnessing Procedure Qualification Record (PQR) tests. On this date, the QA Inspector observed the following personnel present: Smith-Emery Company Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Michael Johnson, ABF Representatives Mr. Tommy Gibson, Mr. Rick Clayborn and welder Mr. Dan Gordon.

At the beginning of the shift the QA Inspector observed the QC Inspector perform informational UT on the PQR plate known as ABF-PQR-003-1A and the QC Inspector evaluated several indications identified in this PQR test plate. It appears ABF decided to remove a portion of the backing bar of the PQR test plate mentioned above to determine the nature of the indications found by UT. The location where the backing bar was removed is approximately (70) millimeters in length and is 160 millimeters from the start of the weld. Upon removal of the back-up bar the QC Inspector did find several round indications (porosity) of various sizes. This PQR test plate will not be Radiographically Tested (RT). See the photo on the right below for additional information.

Later in the Shift the QA Inspector observed the root pass deposited onto (3) non-PQR test plates. These non-PQR test plates were ran in order to set the welding parameters and evaluate the root area. The backing bar was removed from these non-PQR test plates by carbon arc cutting (COC) in order to assess the root area. It was observed that after the backing bar was removed several indications were found. See the photo on the left for additional information.

WELDING INSPECTION REPORT

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Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	White,Danny
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Quality Assurance Inspector

Reviewed By:	Mertz,Robert
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QA Reviewer
